

Work Order ID 160556

Monday, May 01, 2017 1:24:55 PM

160556

Page 1

Item ID: D3016-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Tube

Stop ***NS2***

Start Date: 5/2/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/2/2017 Req'd Qty: 4.00

4

Customer:

Reference: SCHEDULED/C

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 01 2017**

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3016	Rev A
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110

0.00

110

Cold Saw

Memo

0.10

Hyd Mech

CUT TO LENGHT

DAS 32 9-89

17-05-02

120

Manufacture as per dwg

0.00

120

Mill Conv

Memo

0.51

Conventional Milling Machine

USE TOOLING

DAS 32 9-89

17-05-03

130

QC2- Inspect parts off machine FAI/FAIB

0.00

130

QC

Memo

0.08

Quality Control

DAS 32 9-89

17-05-03

Work Order ID 160556

Monday, May 01, 2017 1:24:55 PM

160556

Page 2

Item ID: D3016-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube
Start Date: 5/2/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/2/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.08		<i>17-05-03</i>		<i>11</i>	<i>0</i>		DAS 08 9-89
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>W401</i> Memo	0.00 0.08				<i>11</i>	<i>02</i>	<i>17-5-3</i>	
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.40						<i>17/5/4</i>	<i>28</i>

DAS
21
9-89

MAY 03 2017

Picklist Print

Monday, May 01, 2017 1:24:59 PM

Page 1

Work Order ID: 160556

160556

Parent Item: D3016-3

D3016-3

Parent Item Name: Tube

Start Date: 5/2/2017

Required Date: 5/2/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.08.31 NEW PROCESS DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049		Purchased			No	110	f	58.0160	0.55	2.315789			DAS

M4130NT0 750W 049

**

17-05-02 32 9-89

4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

58.016

m136323

1.066

m136760

32.833

m137091

12.017

m137286

12.1

5.3851



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 160516 MJS
170501

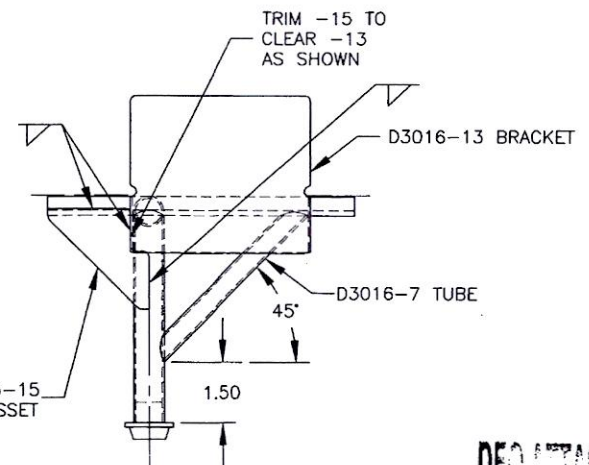
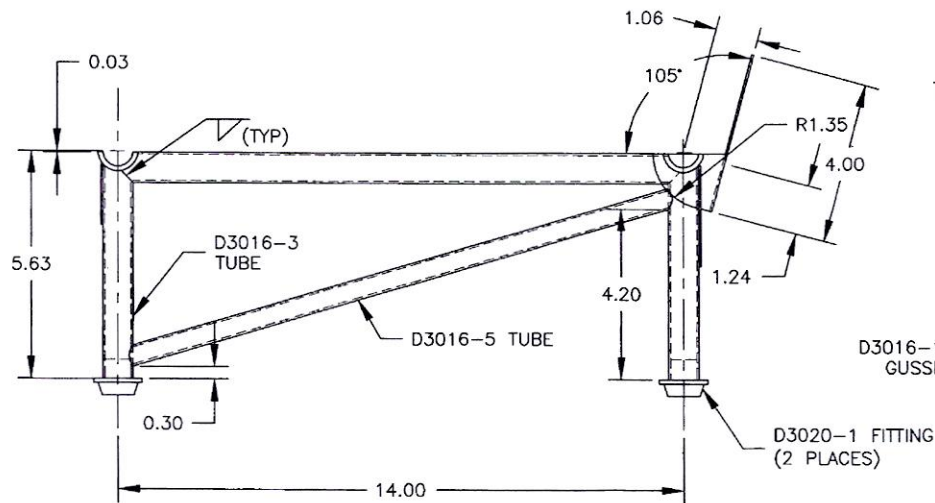
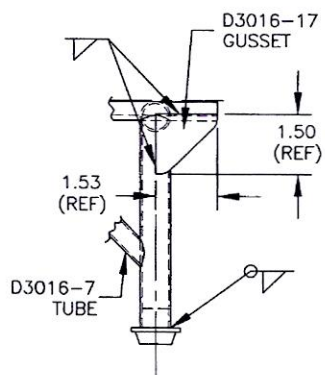
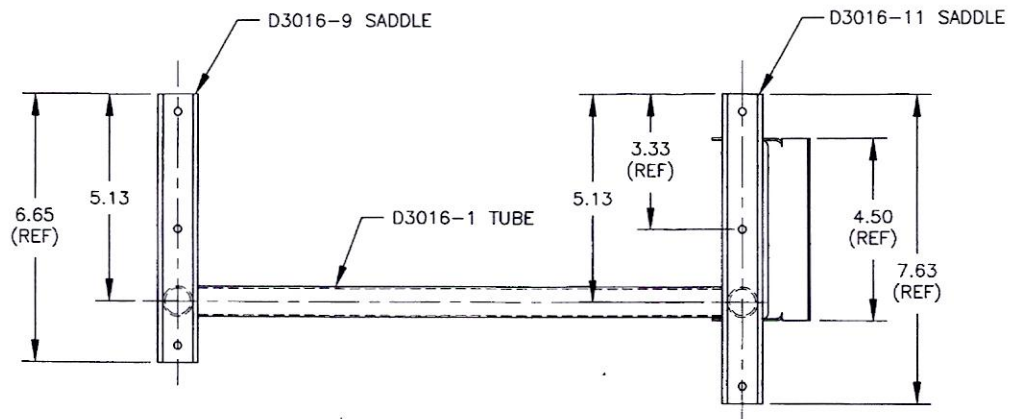
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D3016-041 SEAT FRAME ASSEMBLY

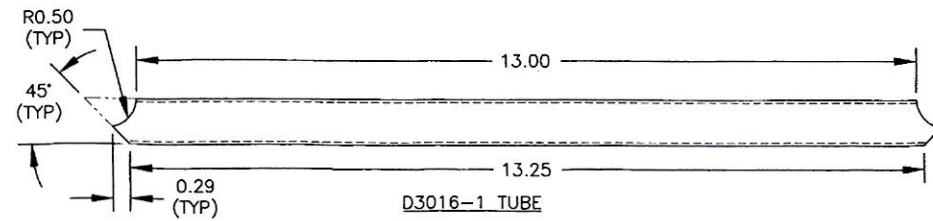
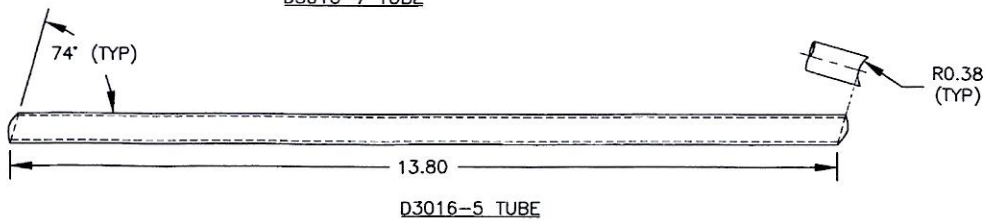
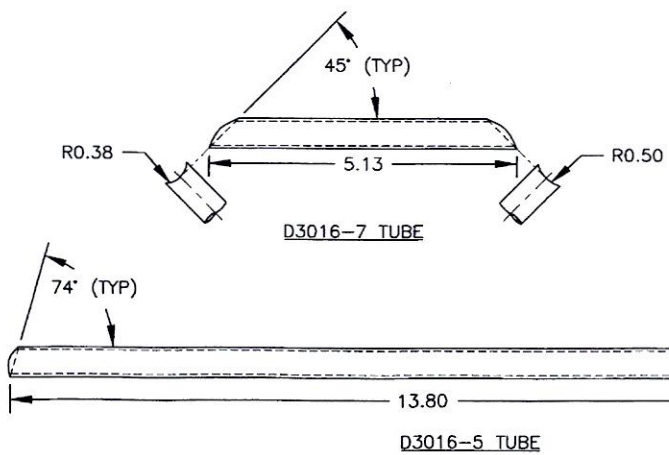
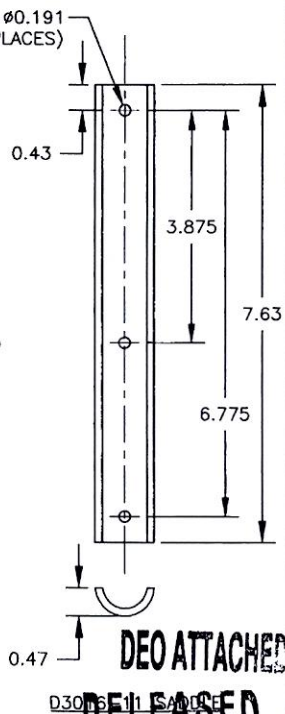
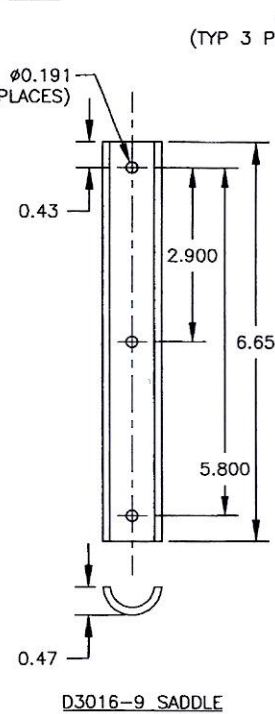
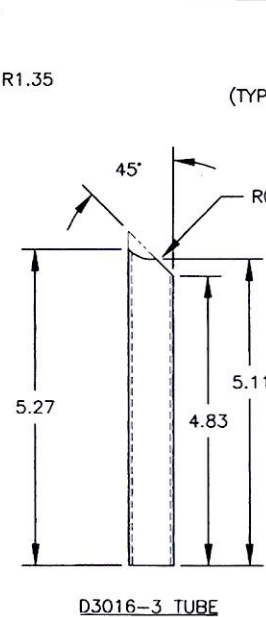
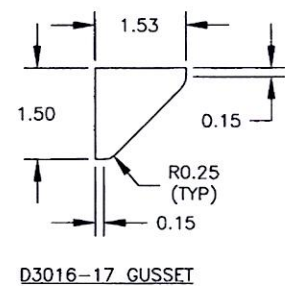
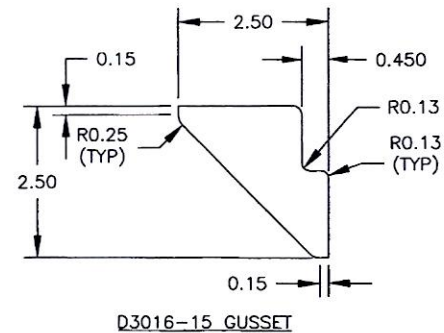
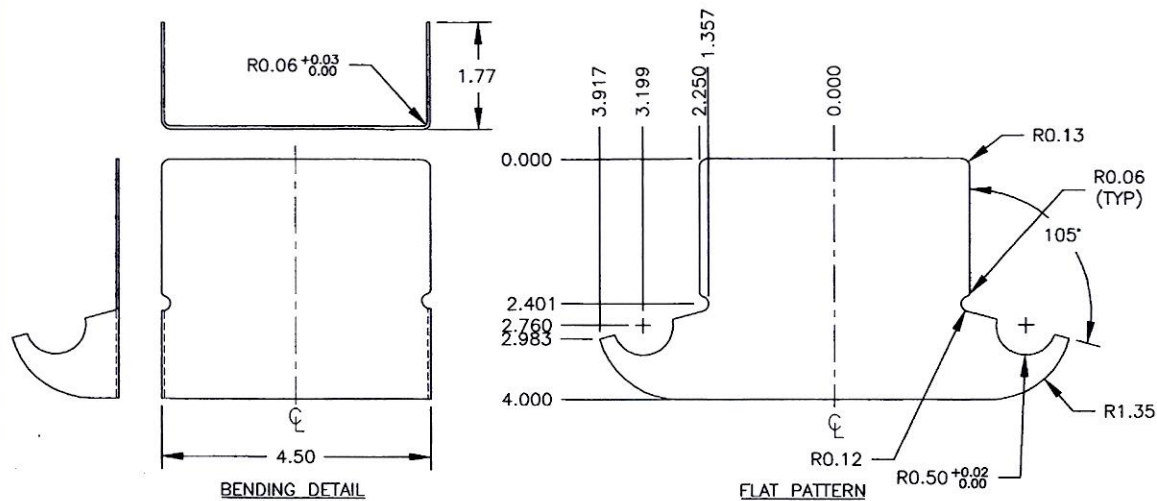


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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SHEET 2 OF 3 SCALE 1:3



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		DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE 1:2	

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9.05.30

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MP</i>	DE APPR. <i>TH</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	

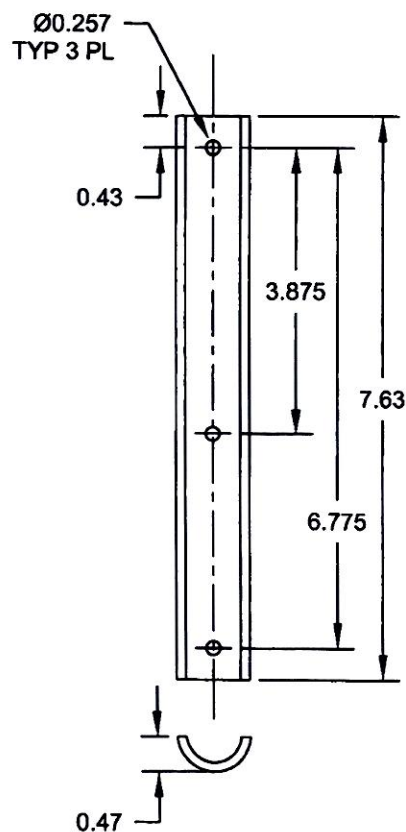
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

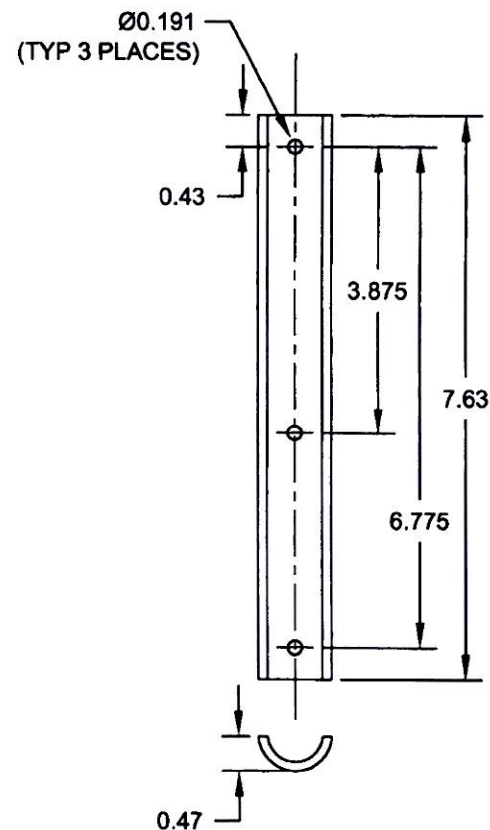
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE